












Date: Thursday, 7/13/2006 3:37:57 PM
User: Kim Johnston

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : MOUNTING LUG |
| Job Number : 27896 | |
| Estimate Number : 10256 | |
| P.O. Number : N/A | Part Number : D22303 |
| This Issue : 7/13/2006 S.O. No. : N/A | Drawing Number : D2230 REV F |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A | Drawing Revision : F |
| Previous Run : 27860 | Material : N/A |
| | Due Date : 8/15/2006 |
| Written By : _____ | Qty: 100 Um: Each |
| Checked & Approved By : <u>JA 06.07.13</u> | |
| Comment : Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC | |
| Additional Product | |
| Job Number:  | |
| Seq. #: | Machine Or Operation: Description : |
| 1.0 | D2423 Lug Extrusion |
|  | |
|  | |
| Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s) Lug Extrusion D2423 Batch: <u>B23119</u> MS 06/08/15 | |
| 2.0 | BAND SAW BAND SAW |
|  | |
|  | |
| Comment: Band Saw Cut D2423 extrusion to 0.82" Batch: <u>B23119</u> MS 06/08/15 103 | |
| 3.0 | HAAS1 HAAS CNC VERTICAL MACHINING #1 |
|  | |
|  | |
| Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2230-3 Check for crack while loading into the machine. ISSUE P.O. 1855 machine per drug D2230 REV F | |
| 4.0 | INSPECT PARTS AS THEY COME OFF MACHINE |
|  | |
|  | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE Receive & inspect for transit damage | |
| 5.0 | SECOND CHECK |
|  | |
|  | |
| Comment: SECOND CHECK Inspect levels | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 06/09/25

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/13/2006 3:37:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 27896

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

N/A

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

06-09-19

a.m. 06-08-19

(100)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-09-19

(100)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

a.m. 06-09-19

(100)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

06/09/25 102

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5T 371

06/09/25

(102)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/25

Job Completion



06/09/25

Dart Aerospace

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

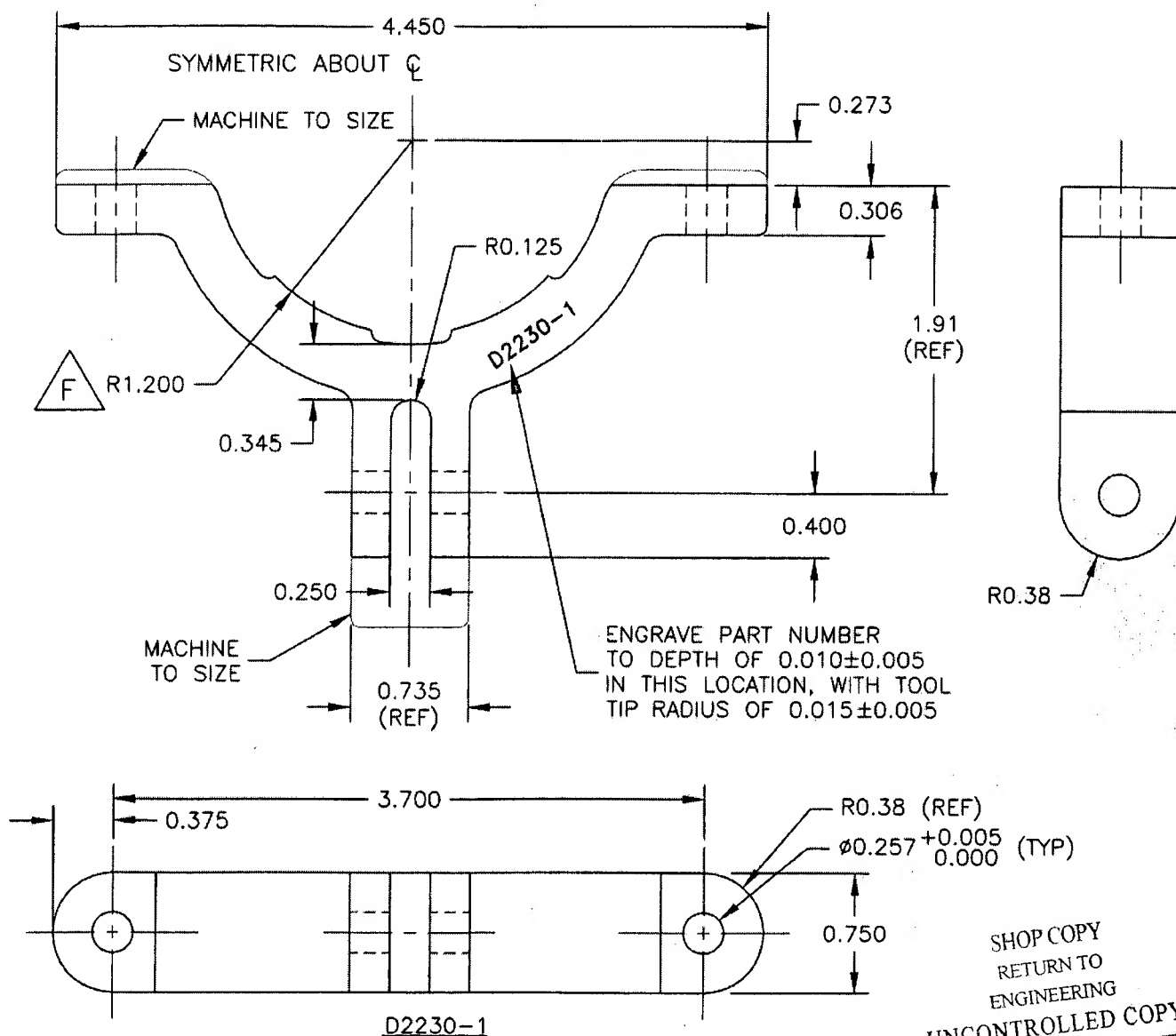
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



| | | | | | |
|-------------------------------|----------|---------------------------------------|--|---|--|
| DESIGN <i>CP</i> | | DRAWN BY <i>CP</i> | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | | APPROVED <i>[Signature]</i> | | DRAWING NO. D2230 REV. F SHEET 1 OF 2 | |
| DATE 99.12.13 | | TITLE MOUNTING LUG SCALE 1:1 | | | |
| C | 94.03.30 | RE-DESIGN | | | |
| D | 95.01.04 | RE-DESIGN | | | |
| E | 95.01.04 | RE-DESIGN | | | |
| F | 99.12.13 | REDESIGN; R1.200 WAS R1.100 | | | |

RELEASED
99-12-21 DS



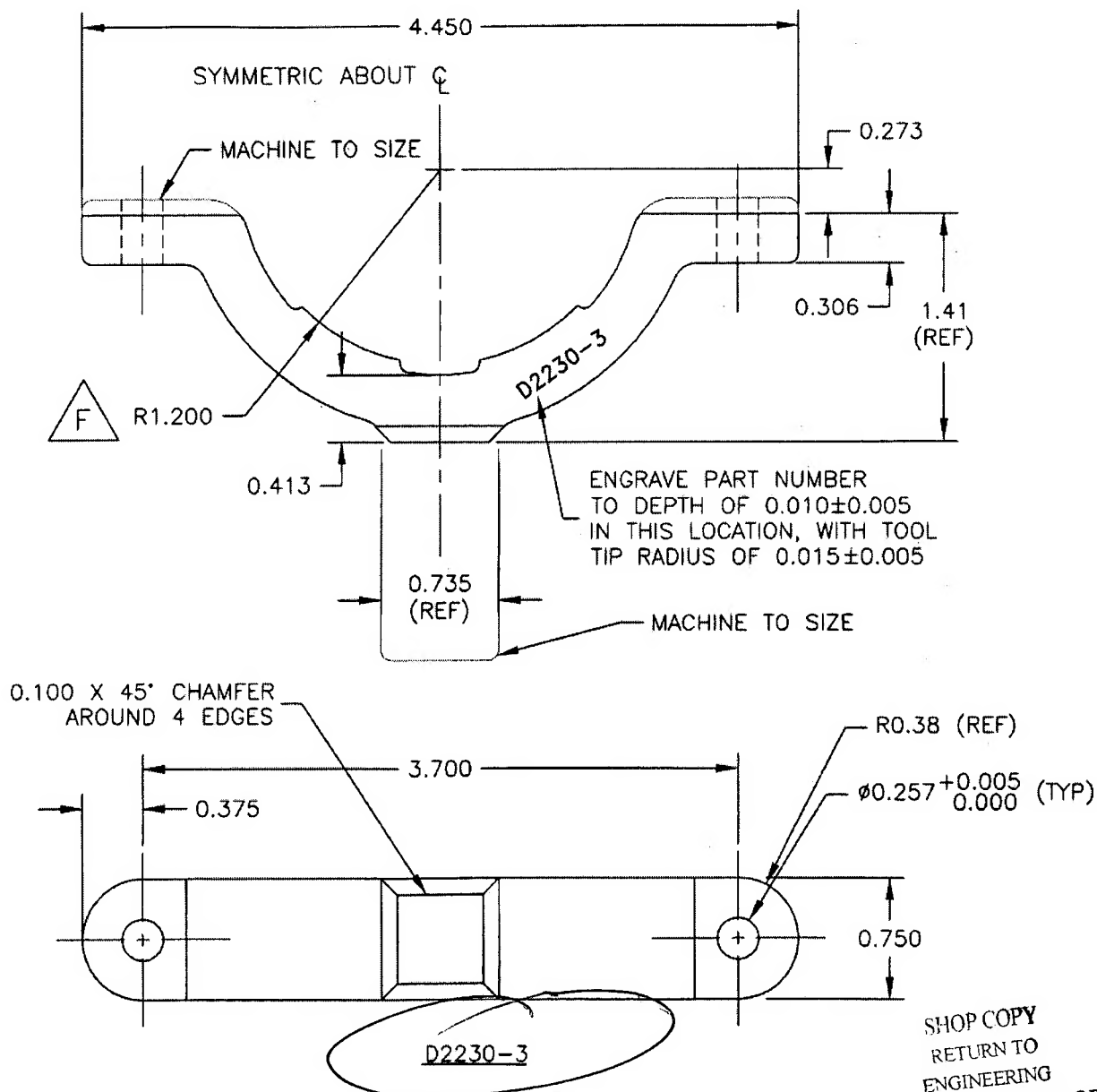
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27896



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2230 | REV. F SHEET 2 OF 2 |
| DATE 99.12.13 | | TITLE MOUNTING LUG | SCALE 1:1 |

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WORK ORDER
NO. 27894



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

102

D 2230-3

Mounting Lug

1855

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, September 8, 2006